Celanese
The chemistry inside innovation™

FORTRON® 6165A6

Polyphenylene sulfide

Fortron 6165A6 is an easier flow version of Fortron 6165A4. It offers similar characteristics to the 6165A4. Applications include electronic components (i.e. lamps housings and sockets) and mechanical components (i.e. pumps and pistons).

Product information

Resin Identification	PPS-(GF+MD)65	ISO 1043
Part Marking Code	>PPS-(GF+MD)65<	ISO 11469

Rheological properties

Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	2.83E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	19600	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.2	%	ISO 527-1/-2
Flexural modulus	2.76E6	psi	ISO 178
Flexural strength	30500	psi	ISO 178
Compressive modulus	2.68E6	psi	ISO 604
Compressive strength	33400	psi	ISO 604
Charpy impact strength, 23°C	9.51	ftlb/in²	ISO 179/1eU
Charpy impact strength, -30°C	9.51	ftlb/in²	ISO 179/1eU
Charpy notched impact strength, 23°C	3.33	ftlb/in²	ISO 179/1eA
Charpy notched impact strength, -30°C	3.33	ftlb/in²	ISO 179/1eA
Izod notched impact strength, 23°C	2.85	ftlb/in²	ISO 180/1A
Izod notched impact strength, -30°C	2.85	ftlb/in²	ISO 180/1A
Izod impact strength, 23°C	9.51	ftlb/in²	ISO 180/1U
Izod impact strength, -30°C	9.51	ftlb/in²	ISO 180/1U
Hardness, Rockwell, M-scale	100		ISO 2039-2

Thermal properties

Melting temperature, 10°C/min	536	°F	ISO 11357-1/-3
Glass transition temperature, 10°C/min	194	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	518	°F	ISO 75-1/-2
Temperature of deflection under load, 8 MPa	419	°F	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	0.11	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.133	E-4/°F	ISO 11359-1/-2
Thermal conductivity, flow	0.7	W/(m K)	ISO 22007-2
Thermal conductivity, crossflow	0.7	W/(m K)	ISO 22007-2
Thermal conductivity, through plane	0.7	W/(m K)	ISO 22007-2
Specific heat capacity of melt	1600	J/(kg K)	ISO 22007-4

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Flammability

Burning Behav. at 1.5mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	0.0591	in	IEC 60695-11-10
Burning Behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.0295	in	IEC 60695-11-10

Electrical properties

Relative permittivity, 1MHz	5.6		IEC 62631-2-1
Dissipation factor, 1MHz	20	E-4	IEC 62631-2-1
Volume resistivity	>1E13	Ohm.m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Electric strength	635	kV/in	IEC 60243-1
Arc Resistance	182	s	UL 746B

Physical/Other properties

Water absorption, 2mm	0.02	%	Sim. to ISO 62
Water absorption, Immersion 24h	0.03	%	Sim. to ISO 62
Density	0.0722	lb/in^3	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	266	°F
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.02	%
Melt Temperature Optimum	626	°F
Min. melt temperature	590	°F
Max. melt temperature	644	°F
Max. screw tangential speed	0.2 - 0.3	m/s
Mold Temperature Optimum	302	°F
Min. mold temperature	284	°F
Max. mold temperature	320	°F
Hold pressure range	4350 - 10200	psi
Back pressure	435	psi
Ejection temperature	426	°F

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Continental	TST N 055 58.01	
Ford	WSF-M4D803-A2	
Mercedes-Benz	DBL5404	Black

Characteristics

Processing	Injection Molding
Additives	Release agent
Special characteristics	Flame retardant, Light stabilized or stable to light, Heat stabilized or stable to heat,

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High Flow, Chemical resistant

Additional information

Injection molding

Preprocessing

Predrying in a dehumidified air dryer at 130 - 140 degC/3-4 hours is recommended.

Processing

On injection molding machines with 15-25 D long three-section screws, as are usual in the trade, the FORTRON is processable. A shut-off nozzle is preferred to a free-flow nozzle.

Melt temperature 320-340 degC
Mold wall temperature at least 140 degC

A medium injection rate is normally preferred. All mold cavities must be effectively vented.

Postprocessing

Tool temperature of at least 135 degC is recommended for parts to achieve maximum crystallizable potential.

Processing Notes

Pre-Drying

FORTRON should in principle be predried. Because of the necessary low maximum residual moisture content the use of dry air dryers is recommended. The dew point should be =< - 30° C. The time between drying and processing should be as short as possible.

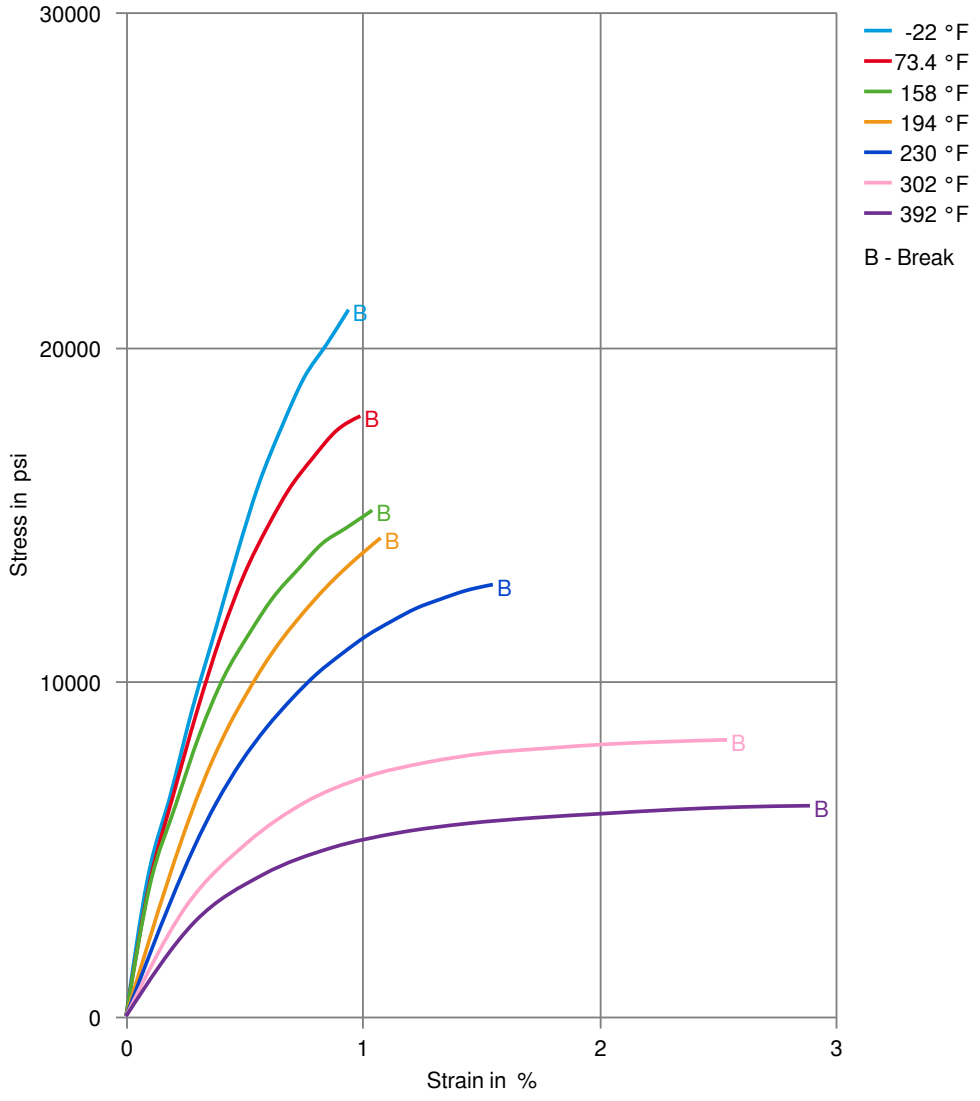
Storage

For subsequent storage the material should be stored dry in the dryer until processed (<= 60 h).

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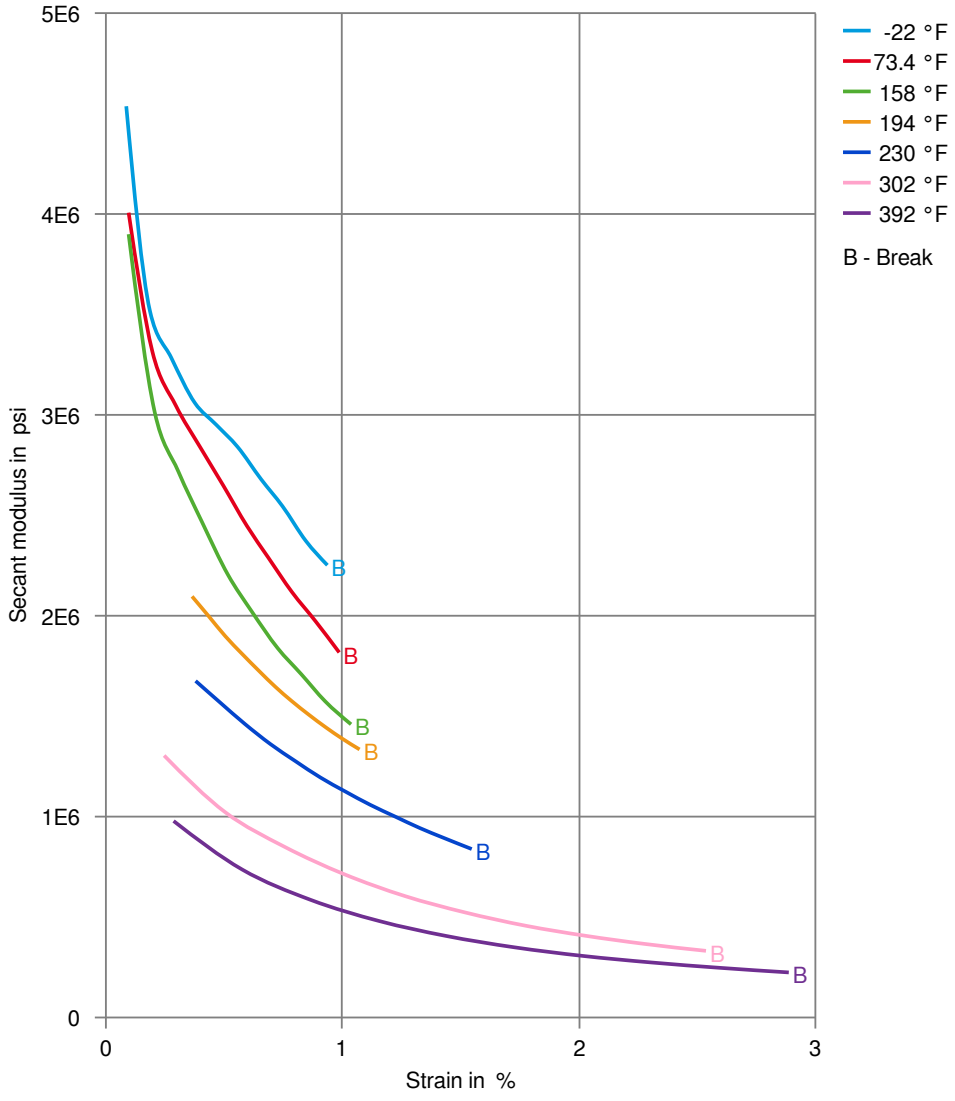
Stress-strain



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Polyphenylene sulfide

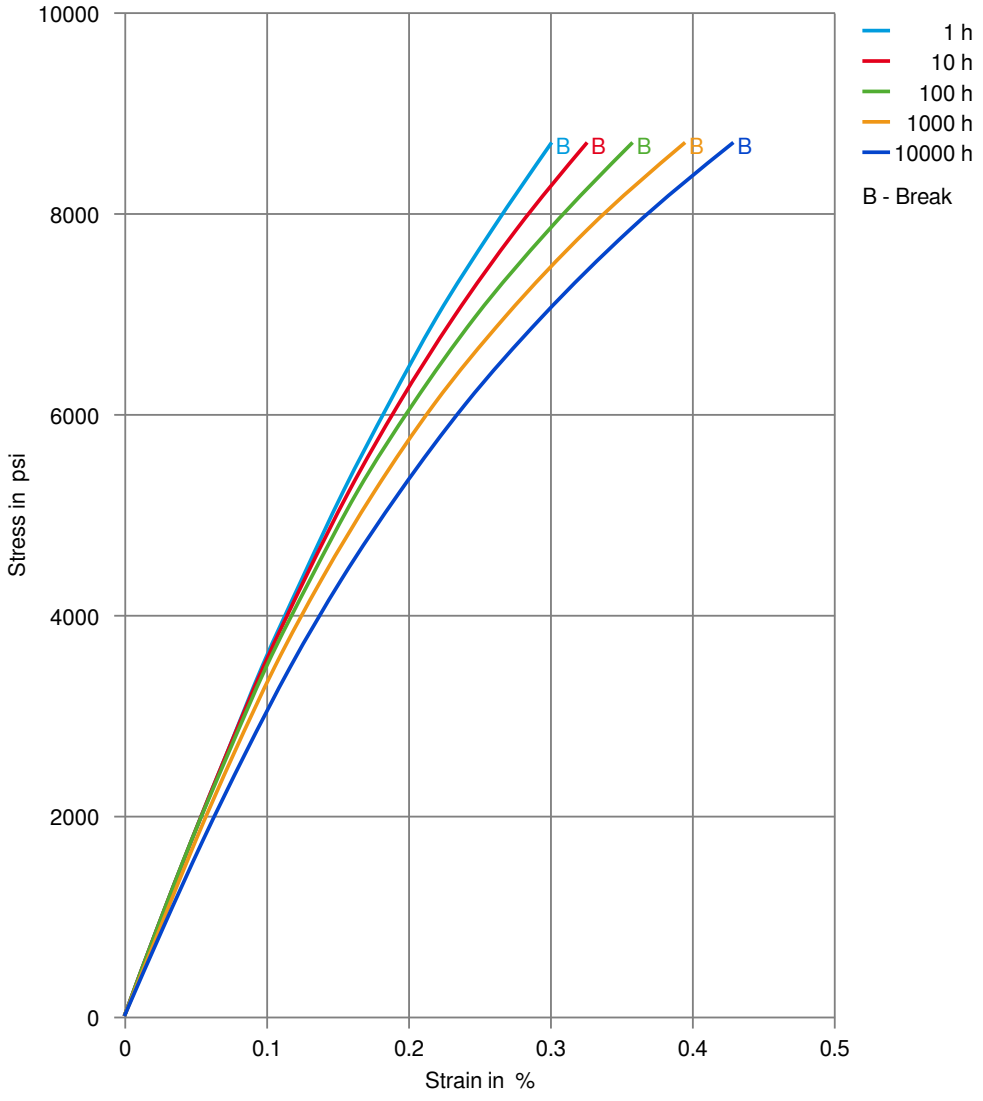
Secant modulus-strain



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Polyphenylene sulfide

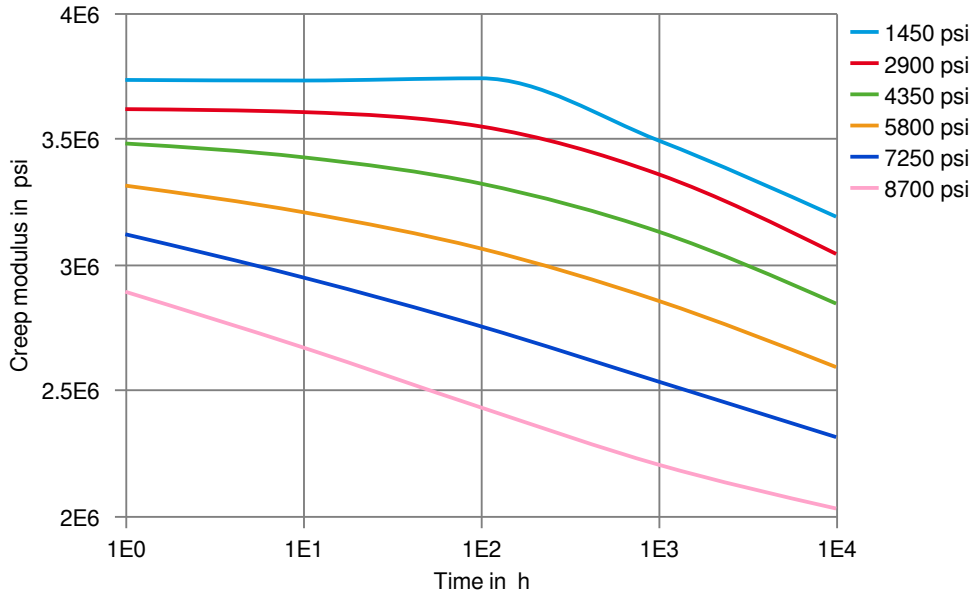
Stress-strain (isochronous) 73.4 °F



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Polyphenylene sulfide

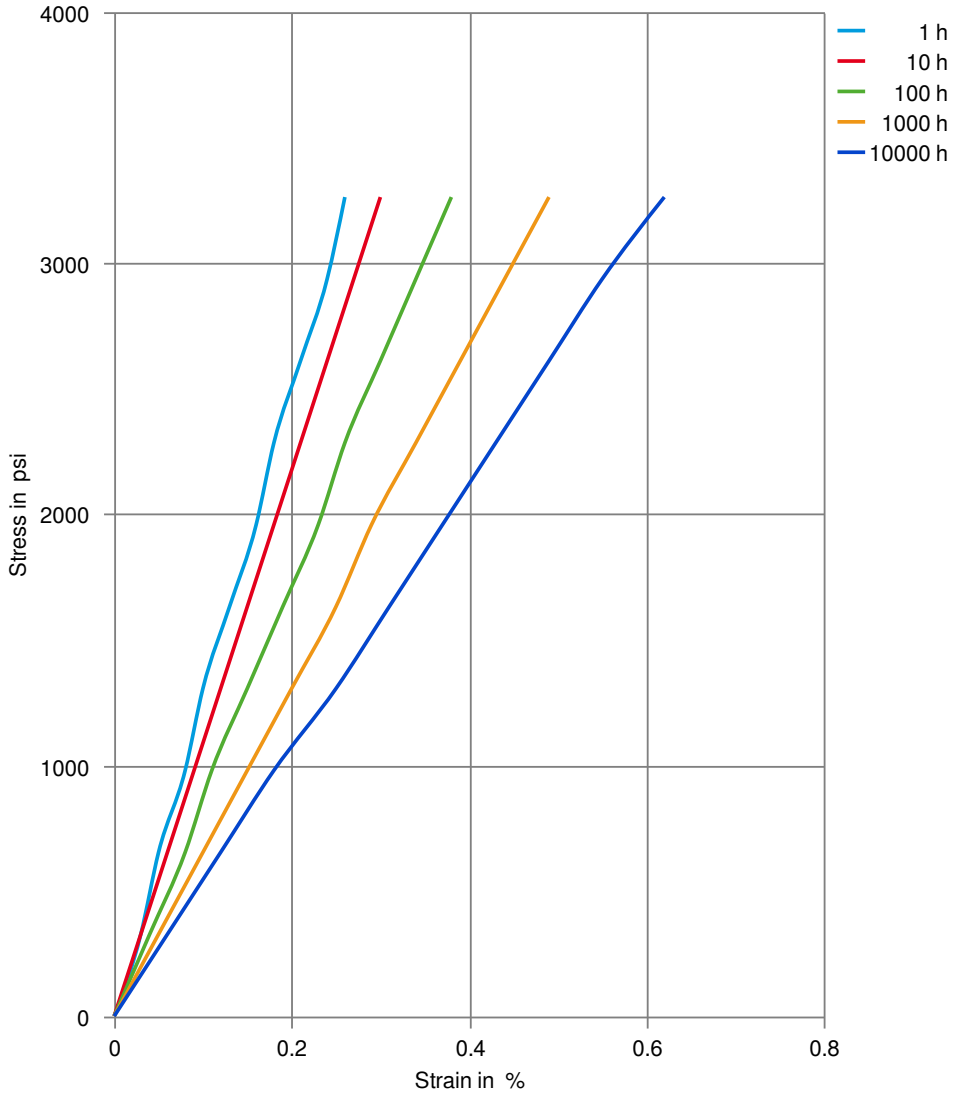
Creep modulus-time 73.4 °F



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Polyphenylene sulfide

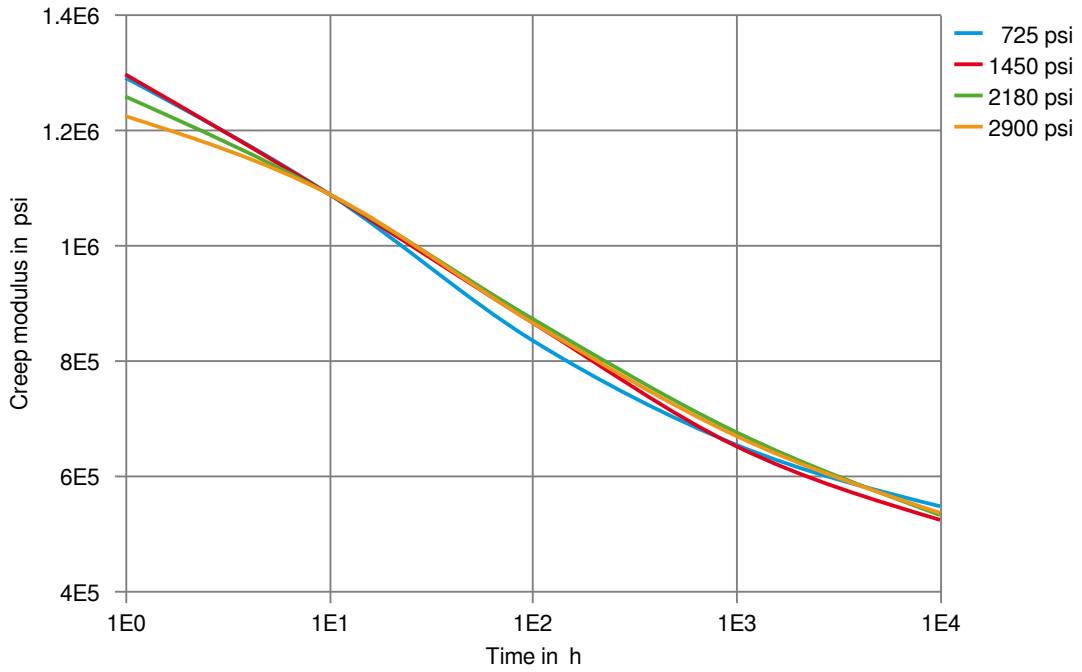
Stress-strain (isochronous) 248 °F



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Polyphenylene sulfide

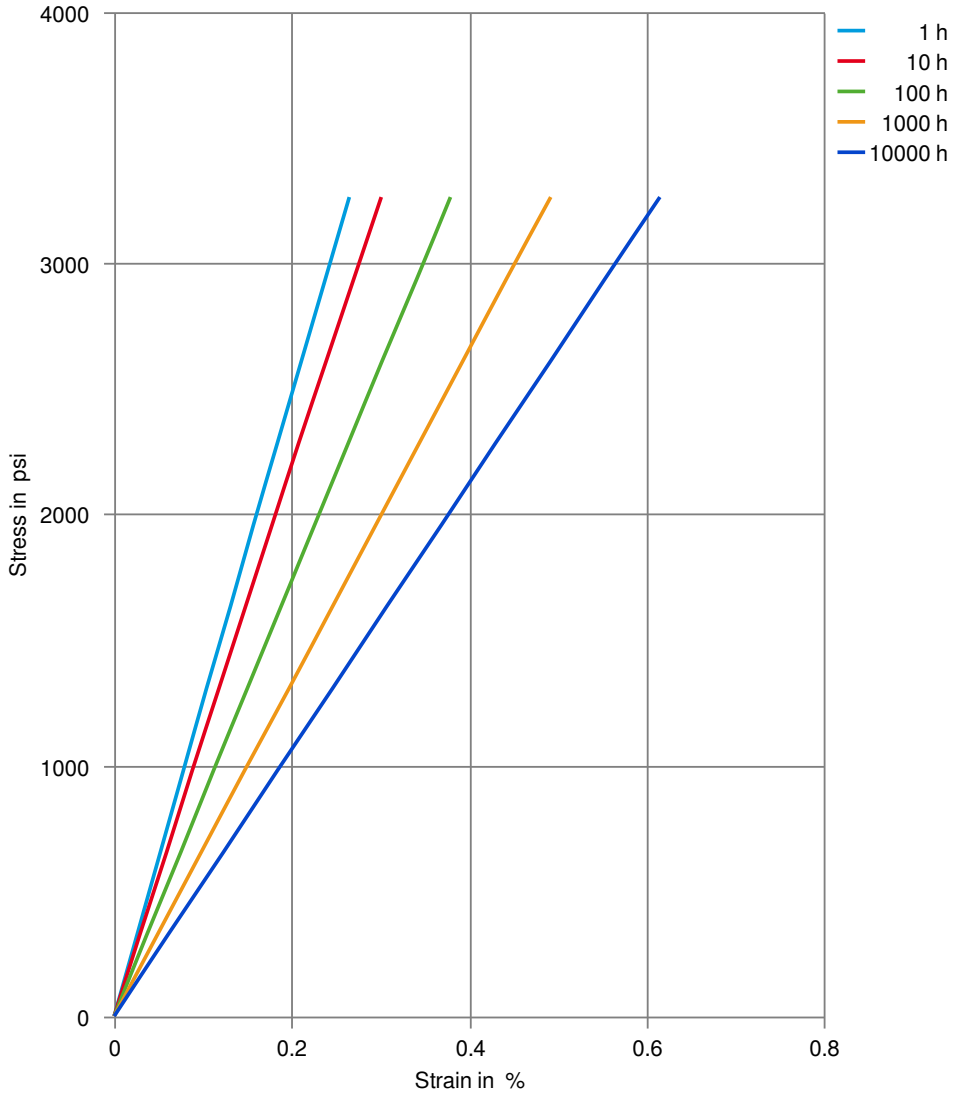
Creep modulus-time 248 °F



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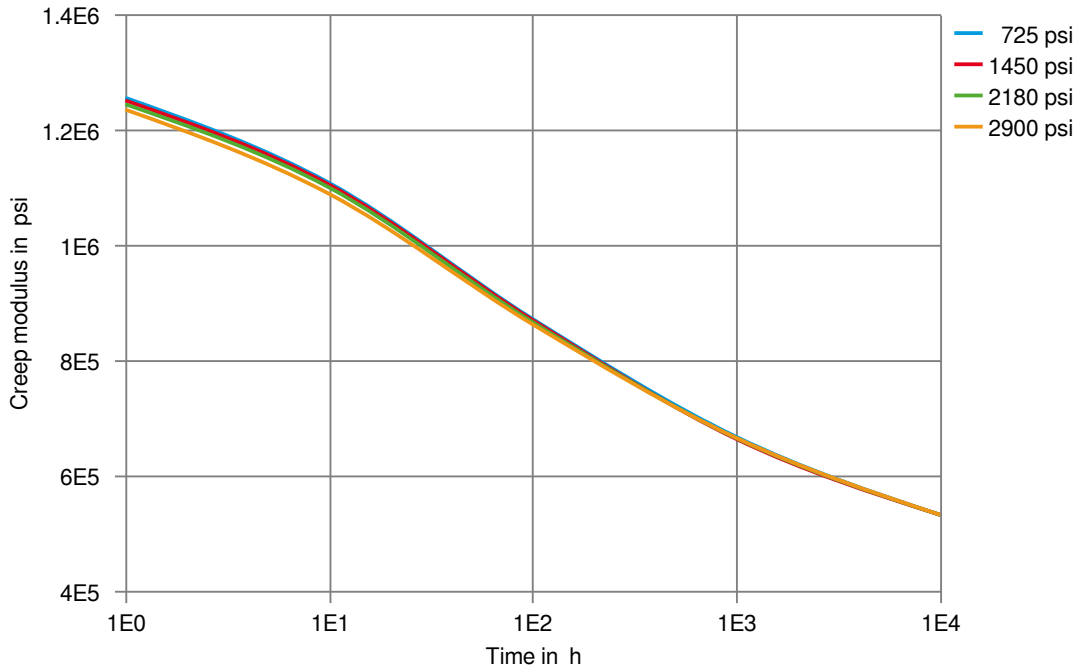
Stress-strain (isochronous) 302 °F



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Polyphenylene sulfide

Creep modulus-time 302 °F

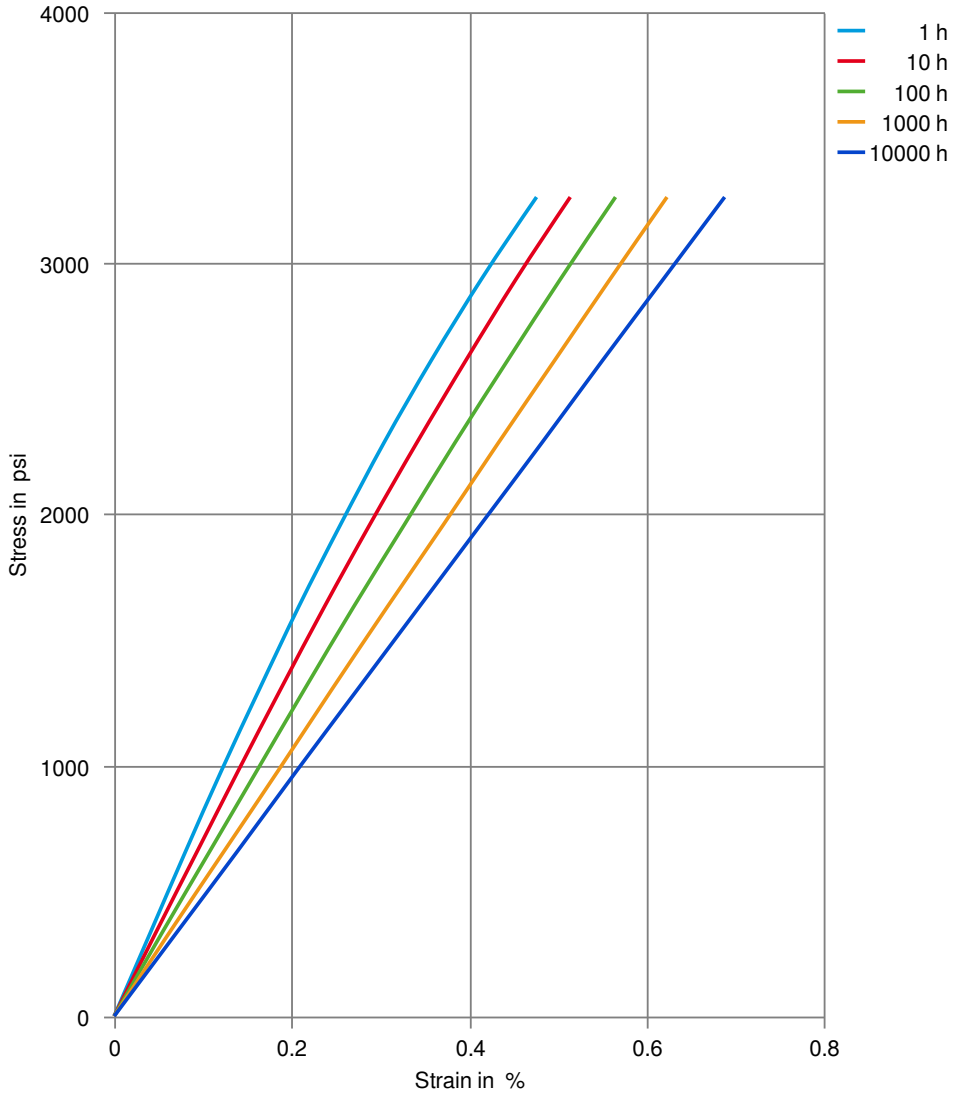


Revised: 2026-09-08 Source: Celanese Materials Database

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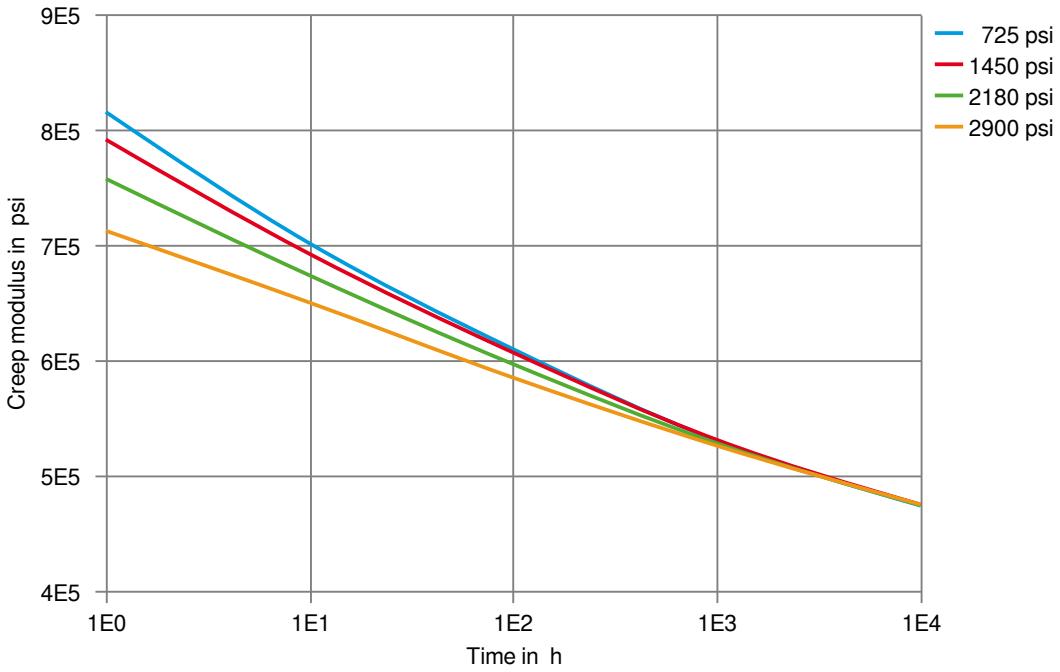
Stress-strain (isochronous) 392 °F



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Creep modulus-time 392 °F



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NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data values. Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Other than those products expressly identified as medical grade (including by MT® product designation or otherwise), Celanese's products are not intended for use in medical or dental implants. Regardless of any such product designation, any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use. To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Moreover, there is a need to reduce human exposure to many materials to the lowest practical limits in view of possible adverse effects. To the extent that any hazards may have been mentioned in this publication, we neither suggest nor guarantee that such hazards are the only ones that exist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards. We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products.
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